

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023260**Date Inspected:** 03-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AE and Seg 13BE:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBE13-002 [Deck Panel (DP) to DP, CJP splice weld]. The welders are identified as 067656, 066163, 068917, 037743, 068097 and 066146 and were observed welding in 1G position. ZPMC Quality Control (QC) was identified as Wang Liang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS):

B-P-2211-B-U2a-FCM-1. Welding was observed to have steel backing remain in place at this weld joint location.

OBG Seg 13AW:

ABF personnel performing Magnetic Particle Testing (MT) of Floor Beam to Side Panel welds (weld joint nos: Seg3013AD-035, 017, 033, 019 and 032) on the FL3 side of the segment. MT was performed after completion of

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the repair welding of the above mentioned welds. The repair welding was performed due to toe cracks previously observed on these welds. See attached photos for further details.

Grillage assembly on Seg 13AW:

This QA Inspector observed that the 5 cope holes requiring corrective action were re-submitted for re-inspection and found to be in general compliance and accepted by the CT SMR Engineer. See attached photo for further details.

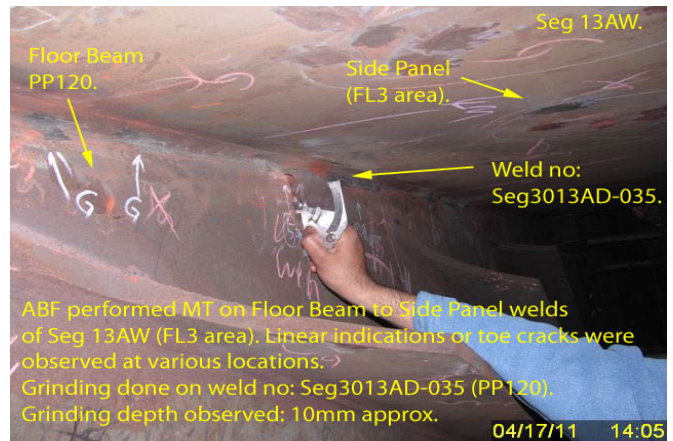
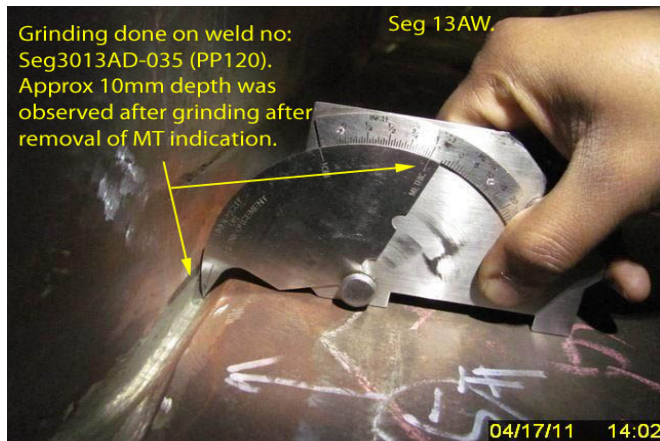
OBG Seg 14W:

ZPMC personnel were performing gas cutting on Floor Beam (FB) 3317A. The alignment of Cross Beam 19 (CB19) to Seg 14W was in progress. See attached photo for further details.

OBG Seg 13BW:

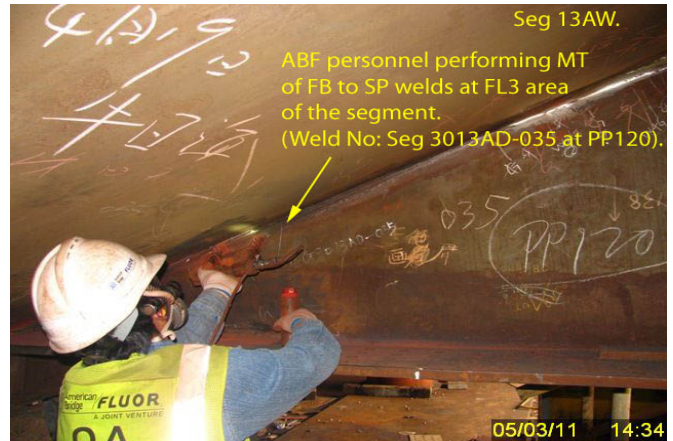
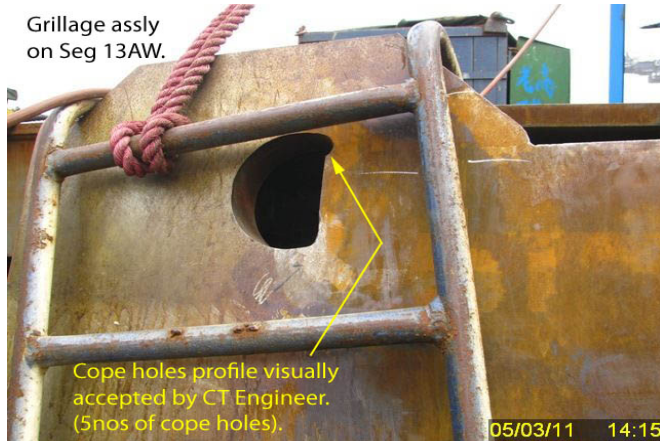
ZPMC personnel performing the oxy-fuel cutting of weld joint: AH3002-026 [of Architectural Housing (on Seg 13BW)]. The weld cutting operation was performed as per Weld Repair Report: WRR 20906 Rev-0. The fit-up of plate X-3398B was required to be performed with the side panel to correct the mis-alignment. See attached photo for details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer